

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026027**Date Inspected:** 27-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG Trial Assembly				

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 13AE (Triangular Plate)

This QA Inspector witnessed final bolt tension verification on bolts connecting triangular plate connecting the stiffeners of Floor Beam and full height Longitudinal Diaphragm at elevations 1772 mm and at 3332mm from Bottom Panel at work point E4 (Cross Beam side) at Panel Points (PP) 120 (east side) for Segment 13AE. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00715 dated July 27, 2011.

The bolt sizes used were M22 x 80 RC Lot # DHGM220140 and the final torque value established was 380 N-m.

The bolt sizes used were M22 x 85 RC Lot # DHGM220121 and the final torque value established was 393 N-m.

The bolt sizes used were M22 x 90 RC Lot # DHGM220141 and the final torque value established was 353 N-m.

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The Manual Torque wrench used was Serial No. XO2-666.

Segment 13BE (Triangular Plate)

This QA Inspector witnessed final bolt tension verification on bolts connecting triangular plate connecting the stiffeners of Floor Beam and full height Longitudinal Diaphragm at elevations 1772 mm and at 3332mm from Bottom Panel at work point E4 (Cross Beam side) at Panel Points (PP) 120.5, PP 121, PP 121.5, PP 122 (east and west side) for Segment 13BE. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00715 dated July 27, 2011.

The bolt sizes used were M22 x 80 RC Lot # DHGM220140 and the final torque value established was 380 N-m.

The bolt sizes used were M22 x 85 RC Lot # DHGM220121 and the final torque value established was 393 N-m.

The bolt sizes used were M22 x 90 RC Lot # DHGM220141 and the final torque value established was 353 N-m.

The Manual Torque wrench used was Serial No. XO2-666.

Segment 13CE (Triangular Plate)

This QA Inspector witnessed final bolt tension verification on bolts connecting triangular plate connecting the stiffeners of Floor Beam and full height Longitudinal Diaphragm at elevations 1772 mm and at 3332mm from Bottom Panel at work point E4 (Cross Beam side) at Panel Points (PP) 122.5, PP 123 and PP 123.5 (east and west side) for Segment 13CE. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00715 dated July 27, 2011.

The bolt sizes used were M22 x 80 RC Lot # DHGM220140 and the final torque value established was 380 N-m.

The bolt sizes used were M22 x 85 RC Lot # DHGM220121 and the final torque value established was 393 N-m.

The bolt sizes used were M22 x 90 RC Lot # DHGM220141 and the final torque value established was 353 N-m.

The Manual Torque wrench used was Serial No. XO2-666.

Segment 13AE and Segment 13BE (Triangular Plate)

This QA Inspector witnessed final bolt tension verification on bolts connecting Angle Splice plates with triangular plate connecting the stiffeners of Floor Beam and full height Longitudinal Diaphragm at elevations 1772 mm and at 3332mm from Bottom Panel at work point E4 (Cross Beam side) at Panel Points (PP) 120 and 121 (east side) for Segment 13AE to Segment 13CE. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00715 dated July 27, 2011.

The bolt sizes used were M27 x 95 RC Lot # DHGM270034 and the final torque value established was 640 N-m.

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The Manual Torque wrench used was Serial No. XO2-666.

Segment 13B and Segment 13BE (Triangular Plate)

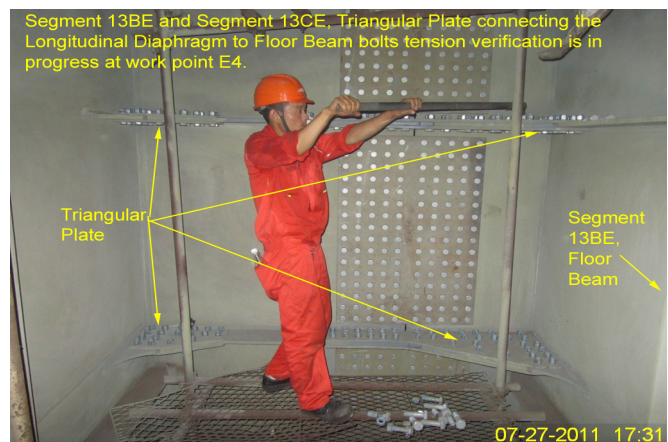
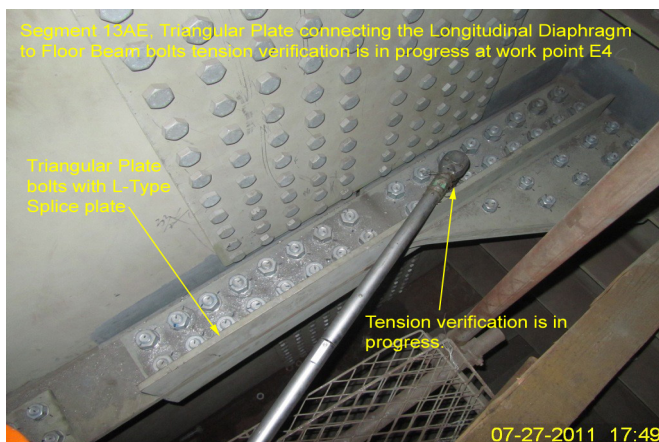
This QA Inspector witnessed final bolt tension verification on bolts connecting Angle Splice plates with triangular plate connecting the stiffeners of Floor Beam and full height Longitudinal Diaphragm at elevations 1772 mm and at 3332mm from Bottom Panel at work point E4 (Cross Beam side) at Panel Points (PP) 120 (east side) for Segment 13AE to Segment 13CE. Inspected the bolt tensioning on a random basis and found the tension to be in general compliance. Inspection was performed against the Notification No. 00715 dated July 27, 2011.

The bolt sizes used were M27 x 95 RC Lot # DHGM270034 and the final torque value established was 640 N-m.

The Manual Torque wrench used was Serial No. XO2-666.

General Note: Please reference the pictures attached for more comprehensive details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Math,Manjunath

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer